

PROCESS FOR FORMING STEEL ROLLER BEARINGS

ABSTRACT OF THE DISCLOSURE

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10 A process for forming a metal, preferably steel, roller bearing comprising the steps of providing a hardened steel cylindrical blank having end face surfaces, a lateral surface defining an outer diameter, and a centered circular bore whose surface defines an inner diameter; hard turning the surface of the bore to a specified inner diameter; and hard turning the lateral surface of the blank to achieve, in a single set up, a final form of the bearing having a specified outer diameter with a radial crown.